

Work Order ID 54940

January 5, 2010 10:16:13 AM



Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Req'd Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PP

Date:

10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

S 10/07/04

HJ for BG 10/03/02

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

RT 10-02-23

R

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 10/02/23

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
2012/11/14	1							

NOTE: Date & initial all entries

Work Order ID 54940



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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1
2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact adhesive
A/R Batch: _____

N/A as per B31836
foam already glued to floor

140

0.00



Small Fab

Small Fab

Memo

0.00

****This step separates hardware, previous steps is for body & floor****

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Reference:

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600
Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with
milled fibres 10% to weight.

A/R Hysol batch: 113022 expire date: 10-09-18

A/R Milled fibres batch: 100859

2- Prime (grey) as necessary per QS1005

Primer batch: 112960

Hardener batch: 113582

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch:

N/A as per B 31836
Foam already glued to floor

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/10/12/25

W/O: 54940		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/23	#150	learn. change change step to install insert to sequ. 150. (110.4)	45 1002 25 CE	10.03.11			8/1 10/02/23

Part No: D350-600-242 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

S 10/02/25

(X)



QC

Memo

0.00

Quality Control

180

Wing Walk as per dwg QSI005 4.4 Batch 113462

0.00

BKR 10-03-2 ①.



HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

190

QC3- Inspect Part Finish

0.00

M 10/03/02

(X) ✓



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-2-22 SF

210

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subtotal

10

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-242

Location:

PPP Rev: B

10-3-5 10 SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date:

Tooling: Date:

Stop

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11
mf
10-3-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
----------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-130

Purchased

No

110

Each

2,717.000

28.0000



Insert

RT 10-02-23

D3015-3

Manufactured

No

130

Each

167.0000

1.0000



Locknut

X28

RT 10-02-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2717

110511

2717

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

117

43758

26

44446

49

48238

42

Main Warehouse

ST59

50

51711

50

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Loca ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R24		Purchased	No			140	Each	112.0000	4.0000			
												
screw												

RT 10-02-23

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

112

104603

20

110179

92

x4

AN960JD516

Purchased

No

140

Each

639.0000

1.0000

Washer

NAS 1149005635

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

639

110363

46

110523

57

111279

39

112082

64

112314

14

112828

28

113149

391

B 113524x1

RT 10-02-23

QSI 012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 		Purchased	No			140	Each	827.0000	4.0000			
Washer												

PT 10-02-23

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		#1
ST	827	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	K4
112314	21	
112385	675	

D2179 Manufactured No

140 Each 79.0000 2.0000



Doubler

PT 10-02-23

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	79	
35432	79	K2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 54940



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237 Striker Plate		Manufactured	No			140	Each	42.0000	2.0000		RT 10-02-23	

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5	
46162	5	
Main Warehouse		
ST022	37	
52327	37	x2

D2986 	Manufactured	No	140	sf	0.0000	5.9158	
-----------	--------------	----	-----	----	--------	--------	--

Black Neoprene Foam .125

D3538-1 	Manufactured	No	140	Each	22.0000	2.0000	
-------------	--------------	----	-----	------	---------	--------	--

Hinge Bracket

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	12	
48197	12	
Main Warehouse		
ST111	10	
50336	10	x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3554-7 		Manufactured	No			140	Each	58.0000	1.0000			
Ball Stud												

17-02-22

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	58	
37674	58	

D3567-2 		Manufactured	No			140	Each	28.0000	1.0000			
Decal												

/

ST 10-02-23

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	28	
39678	9	
50375	19	

MS20426AD4-5 		Purchased	No			140	Each	7,726.000	4.0000			
Rivet												

x1

ST 10-02-23

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7726	
4067	1093	
6733	1651	
6874	4982	

x4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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AN526C832R10		Purchased	No			150	Each	245.0000	8.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	245	
104603	95	
113154	100	
113288	50	

X 8

AN526C832R14		Purchased	No			150	Each	883.0000	2.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	883	
104916	883	

X 2

RT 10-02-23

RT 10-02-23

W/O:		WORK ORDER CHANGES					
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AN960JD10 		Purchased	No			150	Each	1,128.000	2.0000			
Washer											10-02-23	

NAS1149 D03637
QSI 017 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1128

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

78

112369

22

113149

738

B113288

W/O:		WORK ORDER CHANGES					
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Comments:

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AN960JD8  Washer		Purchased	No			150	Each	827.0000	16.0000		10-2-22	SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	827	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	16
112314	21	
112385	675	

D2228 Manufactured No



Bracket Plate

150 Each 76.0000 4.0000

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	76	
30679	33	4
48228	43	

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Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2464  3/4 Seal		Manufactured	No			150	f	731.7510	11.3684			

10-2-22 sl

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	731.7509737	
39669	89.87	
48173	641.880974	

D2585

Manufactured No

150 Each 68.0000 2.0000



Mounting Channel

10-2-22 sl

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	64	
45888	4	
53798	60	
Main Warehouse		
ST37	4	
51526	4	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2586  Door Latch		Manufactured	No			150	Each	67.0000	2.0000			

10-2-22 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	67	
45554	1	
50213	66	


2

D2621  Latch Plate, 350 Spacepod		Manufactured	No			150	Each	66.0000	2.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

10-2-22 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	66	
46842	66	

1

D2857-1  Hinge Bracket		Manufactured	No			150	Each	18.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

10-2-22 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
41166	7	
45788	1	
53464	10	

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 05/01/2010

Required Date: 18/01/2010


Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	East Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-2  Hinge Bracket		Manufactured	No			150	Each	14.0000	1.0000		10-2-22 SP	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
45797	2	
53465	12	

D3557-1  Bracket		Manufactured	No			150	Each	22.0000	1.0000		10-2-22 SP	
---	--	--------------	----	--	--	-----	------	---------	--------	--	------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
32647	1	
46887	6	
50283	15	

D3567-2  Decal		Manufactured	No			150	Each	28.0000	1.0000		10-2-22 SP	
---	--	--------------	----	--	--	-----	------	---------	--------	--	------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	28	
39678	9	
50375	19	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08		Purchased	No			150	Each	151.0000	18.0000			
												
Nut												

M113595 sf 10-2-22

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	151	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	29	

MS21042L3		Purchased	No			150	Each	3,014.000	2.0000			
												
Nut												

10-2-22 sf

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3014	
110844	35	
111274	27	
111668	64	
112314	1388	
112385	500	
113523	300	
113537	700	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-08-11		Purchased	No			150	Each	54.0000	2.0000			
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

54

111977

54

MS27039-1-15

Purchased

No

150

Each

141.0000

2.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

141

106903

3

108169

4

109321

4

111916

30

112794

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3  Washer		Purchased	No			150	Each	476.0000	2.0000			

10-2-22 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	476	
109268	259	
110397	87	
111268	130	

AN526C832R10  Screw	Purchased	No
--	-----------	----

200 Each 245.0000 2.0000

2
10-2-22 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	245	
104603	95	
113154	100	
113288	50	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516

Purchased

No

200

Each

639.0000

2.0000

Washer

7AS1149005634

PSI 017 SP

M113527 10-2-22 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

639

110363

46

110523

57

111279

39

112082

64

112314

14

112828

28

113149

391

AN960JD8

Purchased

No

200

Each

827.0000

12.0000

Washer

10-2-22 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

827

107091

9

108335

11

110382

48

110917

3

111578

60

112314

21

112385

675

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2985

Manufactured

No

200

Each

18.0000

1.0000



Label

10-2-22 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

48236

8

50232

10

D350-600-449

Manufactured

No

200

Each

4.0000

1.0000



Switch Relocation

10-2-22 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

4

50244

4

D3547-1

Manufactured

No

200

Each

21.0000

1.0000



Bracket

10-2-22 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

21

35455

7

50260

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3550-1

Manufactured

No

200

Each

16.0000

1.0000

Strut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

48367

16

D3552-7

Manufactured

No

200

Each

10.0000

1.0000

Door Prop

N/A in K10021

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

52451

10

D3554-7

Manufactured

No

200

Each

58.0000

1.0000

Ball Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

58

37674

58

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:16:18 AM

Work Order ID: 54940



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S K10021 Spacepod Hardware Kit (-241)		Manufactured	No		200	Each	1.0000	1.0000		10-2-2010	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FG	1	
50276	1	

MS21042L08



Nut

Purchased

No

200

Each

151.0000

14.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	151	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	29	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355



Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00





Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3188-2M		Manufactured	No		110	Each	2.0000	1.0000			
											
SPACEPOD BODY RH											

RT 10-02-23

353075

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
CA	2	
46180A	1	
53074	1	

D3186-4		Manufactured	No		110	Each	0.0000	1.0000			
											
Spacepod Door, RH											
D3187-2		Manufactured	No		110	Each	4.0000	1.0000			
											
Spacepod Floor											

354947

RT 10-02-23

10-2-22 sf

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4	
31836	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 54940

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355


Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty	Qty Issued	Date Issued	Status
A3235-020-935		Purchased	No		110	Each	686.0000	8.0000			
											
Washer - Countersunk											

10-2-22 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	686	
104156	3	
106150	683	

D3015-3

Manufactured No



Locknut

200 Each 167.0000 1.0000

10-2-22 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	117	
43758	26	
44446	49	
48238	42	
Main Warehouse		
ST59	50	
51711	50	

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/516A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/1-5	DT8003	DT8501
D3188-2M/2-6	DT8004	DT8502
D3188-3M/3-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54940
BY 10-1-05

RELEASED
2009-10-20
MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0609-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/2M/3M/5-6/7	CS	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED HEREIN. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

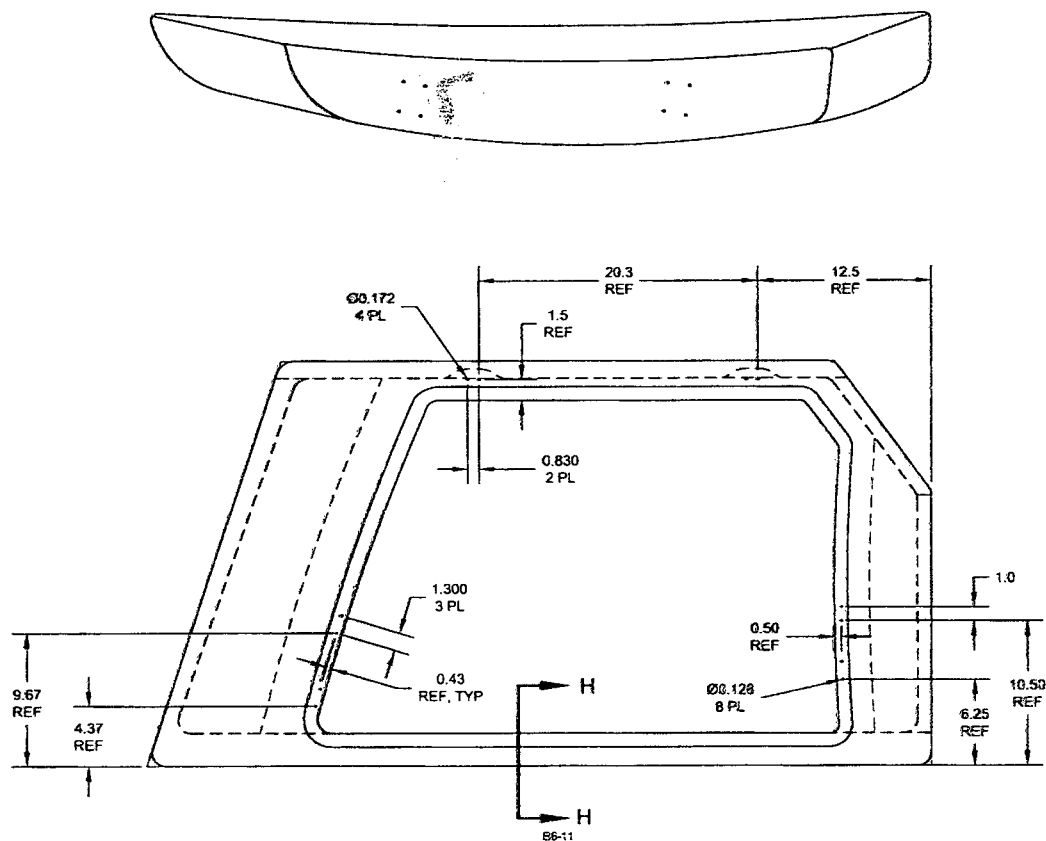
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-28
N/A

W/O 54940

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
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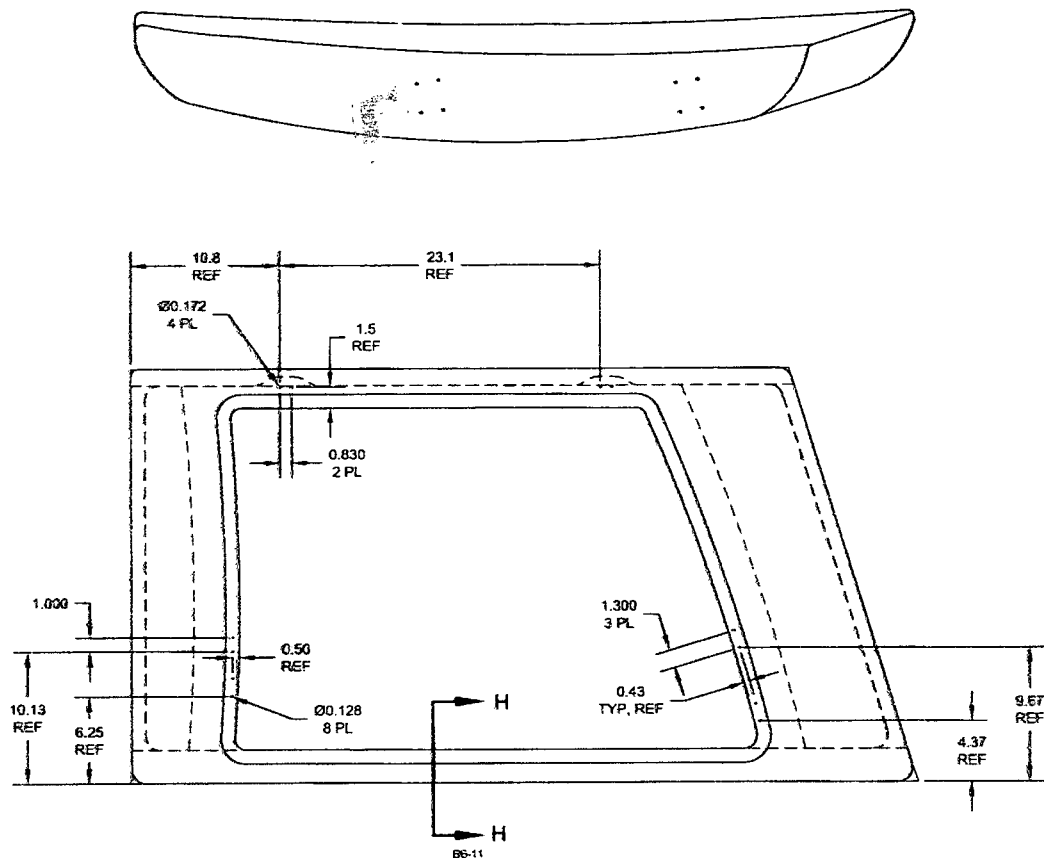
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
MP

W/0 54940

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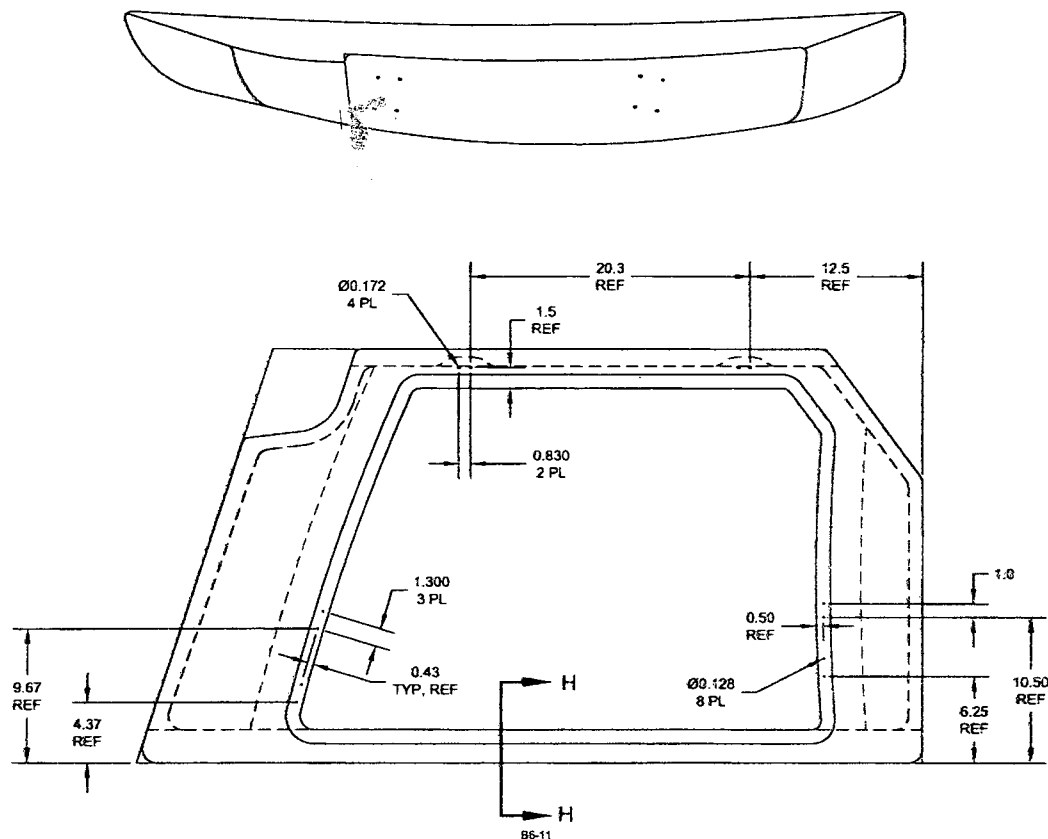
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20

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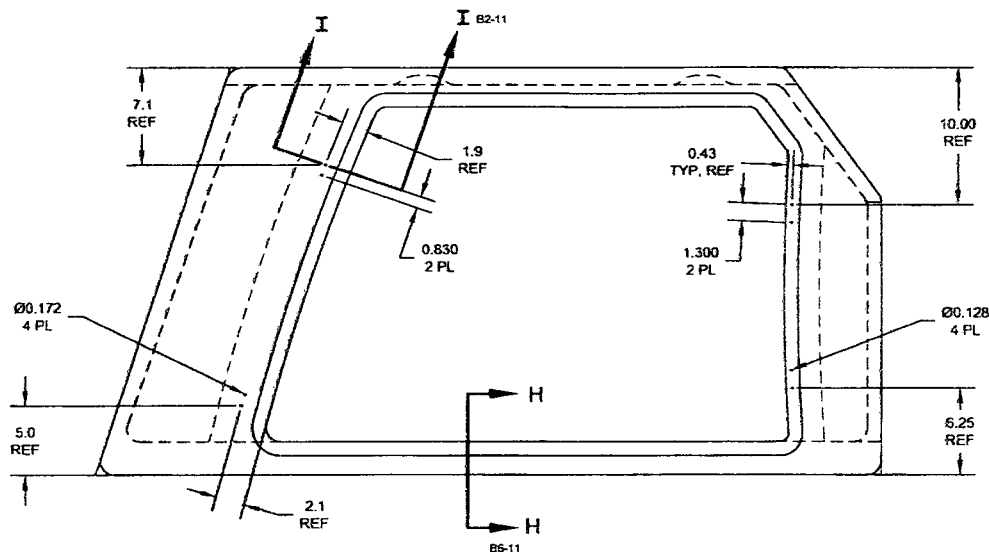
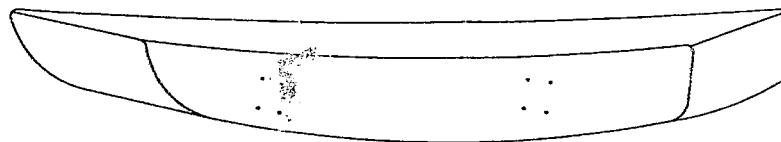
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2009-10-20

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
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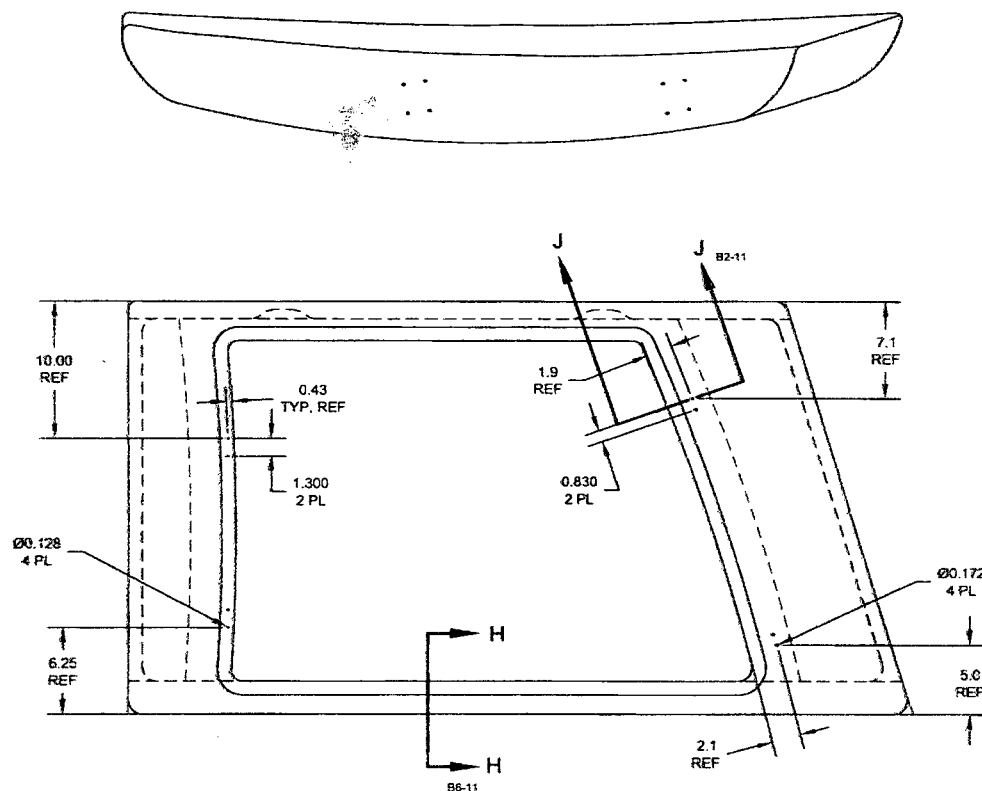
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2009-10-20

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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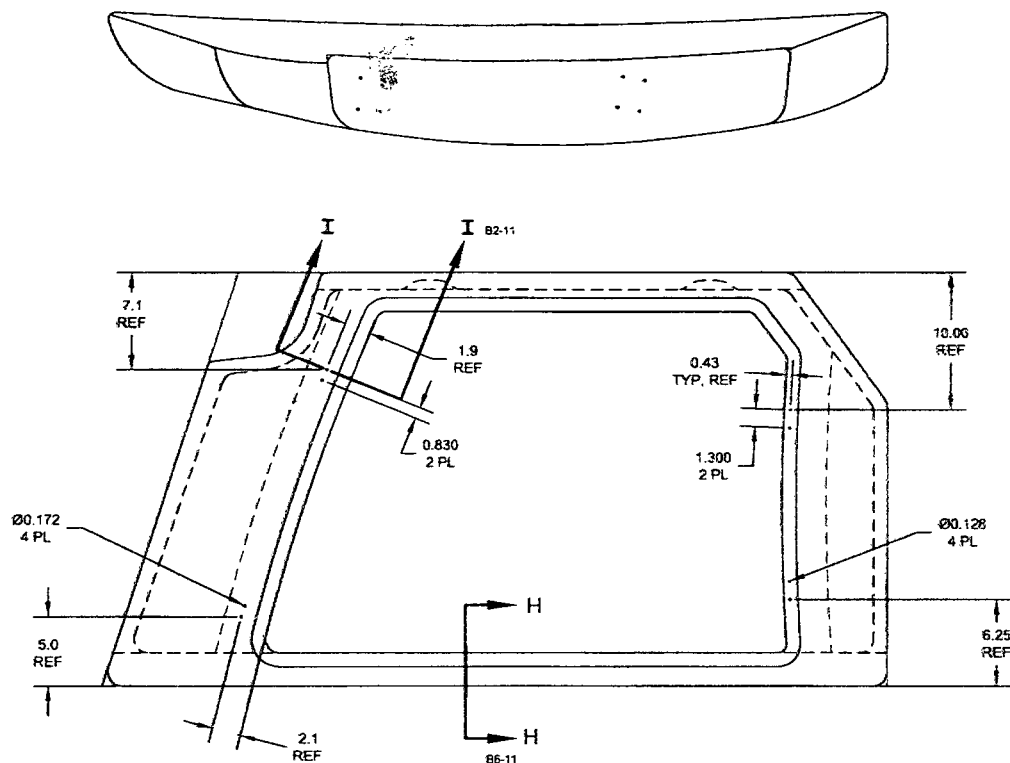
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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2009-10-20

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MFG. APPR.		D3188	SHEET 7 OF 11
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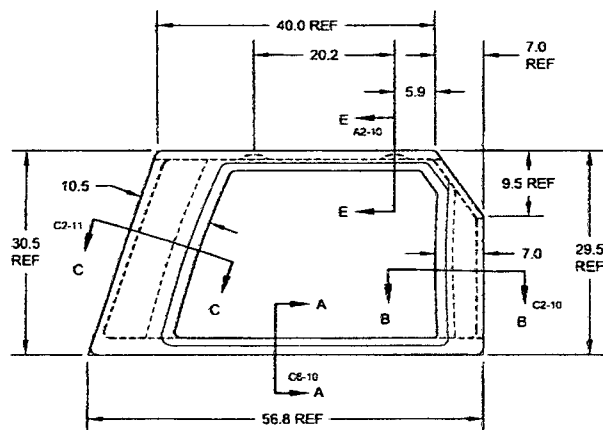
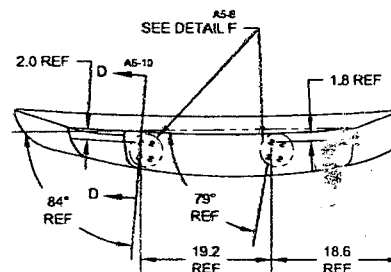
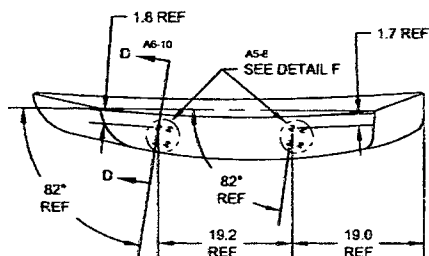
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

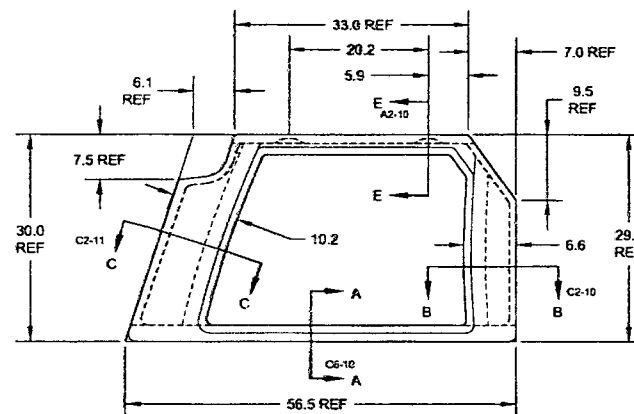
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

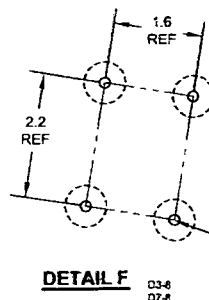
NOTE: Date & initial all entries



D3186-1M SPACEPOD BODY



D3186-3M SPACEPOD BODY



DETAIL F

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

D3186-1M/3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2009-10-23

W1054240

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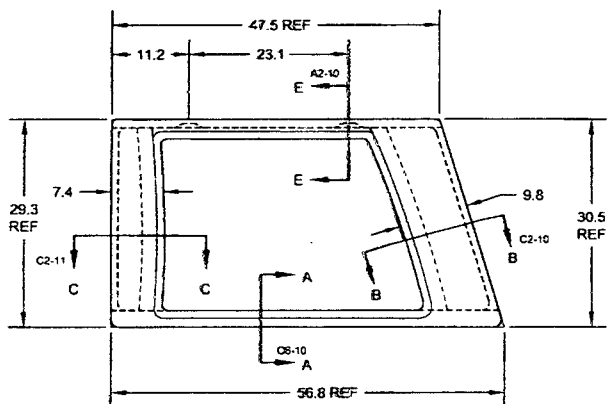
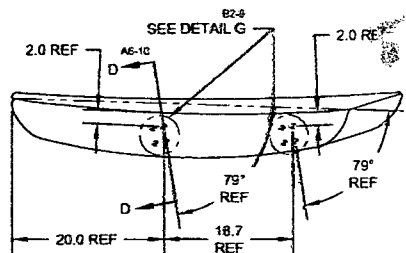
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

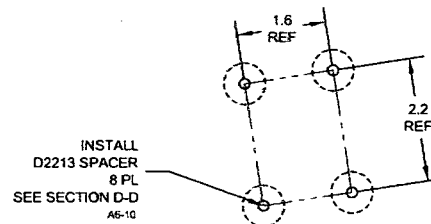
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-2M SPACEPOD BODY



DETAIL G D6-6

RELEASED
2009-10-20

D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

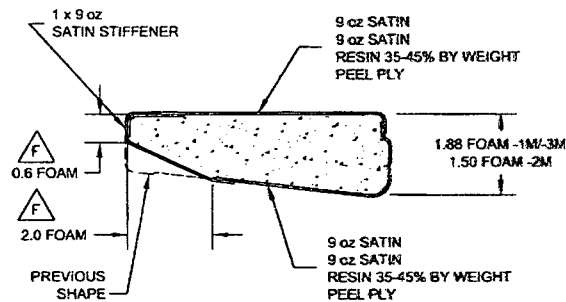
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

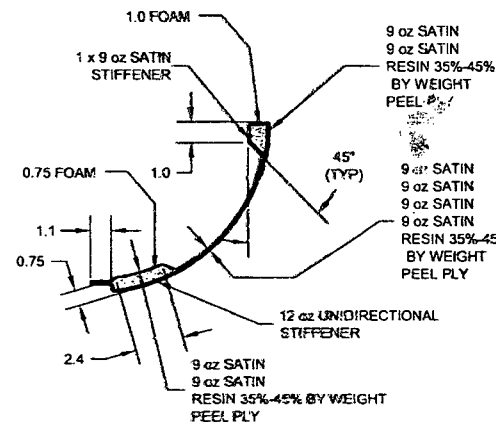
NOTE: Date & initial all entries

OUTBOARD



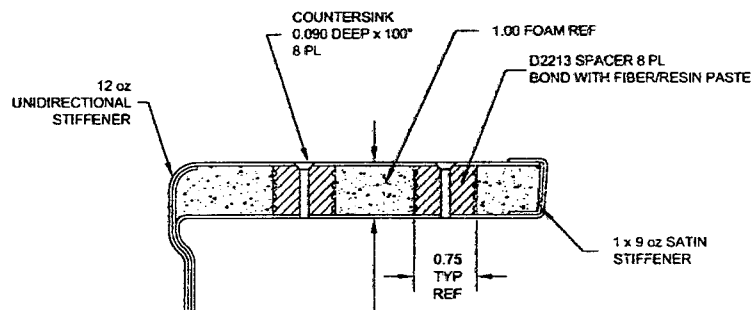
SECTION A-A
TYPICAL FLOOR SECTION

B7-8
B3-8
B6-8



SECTION B-B
SECTION C-C OPPOSITE

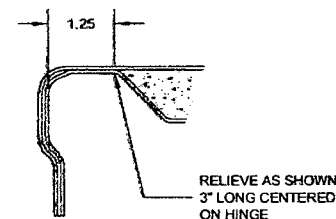
B6-8
B8-8
B4-8
B2-8
B7-9
B5-9



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

B3-8
B7-8
B6-8

9 oz SATIN
9 oz SATIN
18 oz CLOTH
1.00 FOAM
9 oz SATIN
9 oz SATIN
RESIN 35-45% BY WEIGHT
PEEL PLY



SECTION E-E
2 PLACES PER POD

C2-8
C7-8
B6-8

RELEASED
2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
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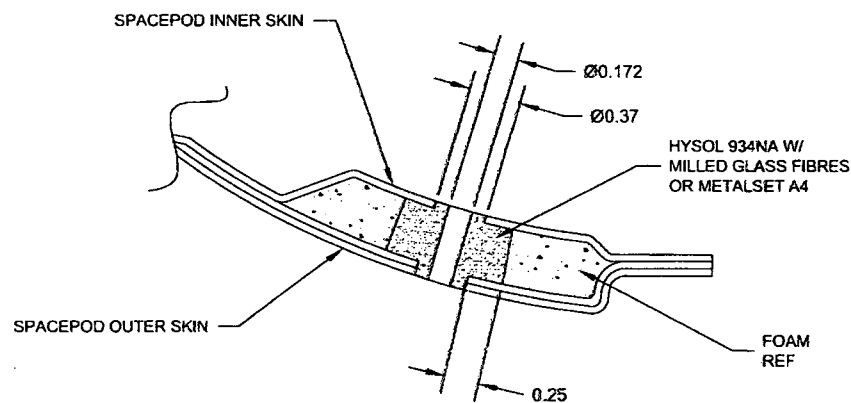
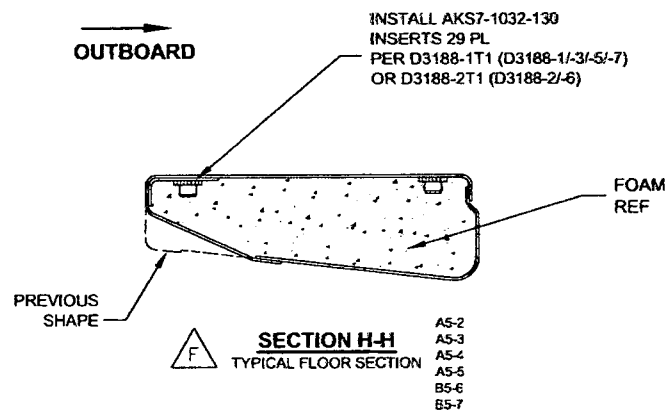
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION H
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C5-7

RELEASED
2009-10-20

4510 54940

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 11 OF 11
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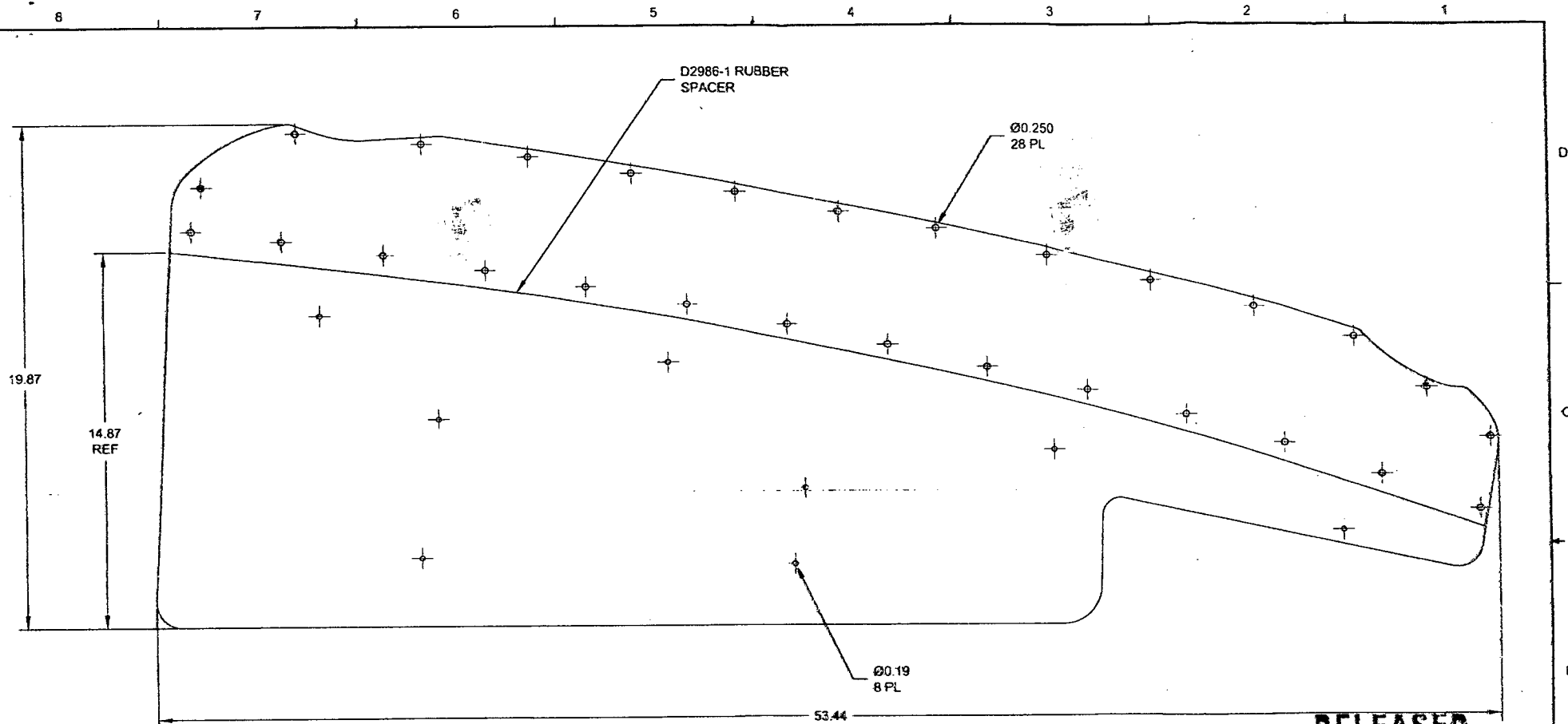
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3187-1 SPACEPOD FLOOR

D3187-1 SPACEPOD FLOOR NOTES:



1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER

7) WEIGHT: 4.2 LBS

8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1

9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09-01-05

C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1T-2.	MB	09.01.05
B	CHANGE SHAPE	CP	03.05.16
A	NEW ISSUE	CP	03.03.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3187 SHEET 1 OF 2
TITLE SCALE
SPACEPOD FLOOR NTS

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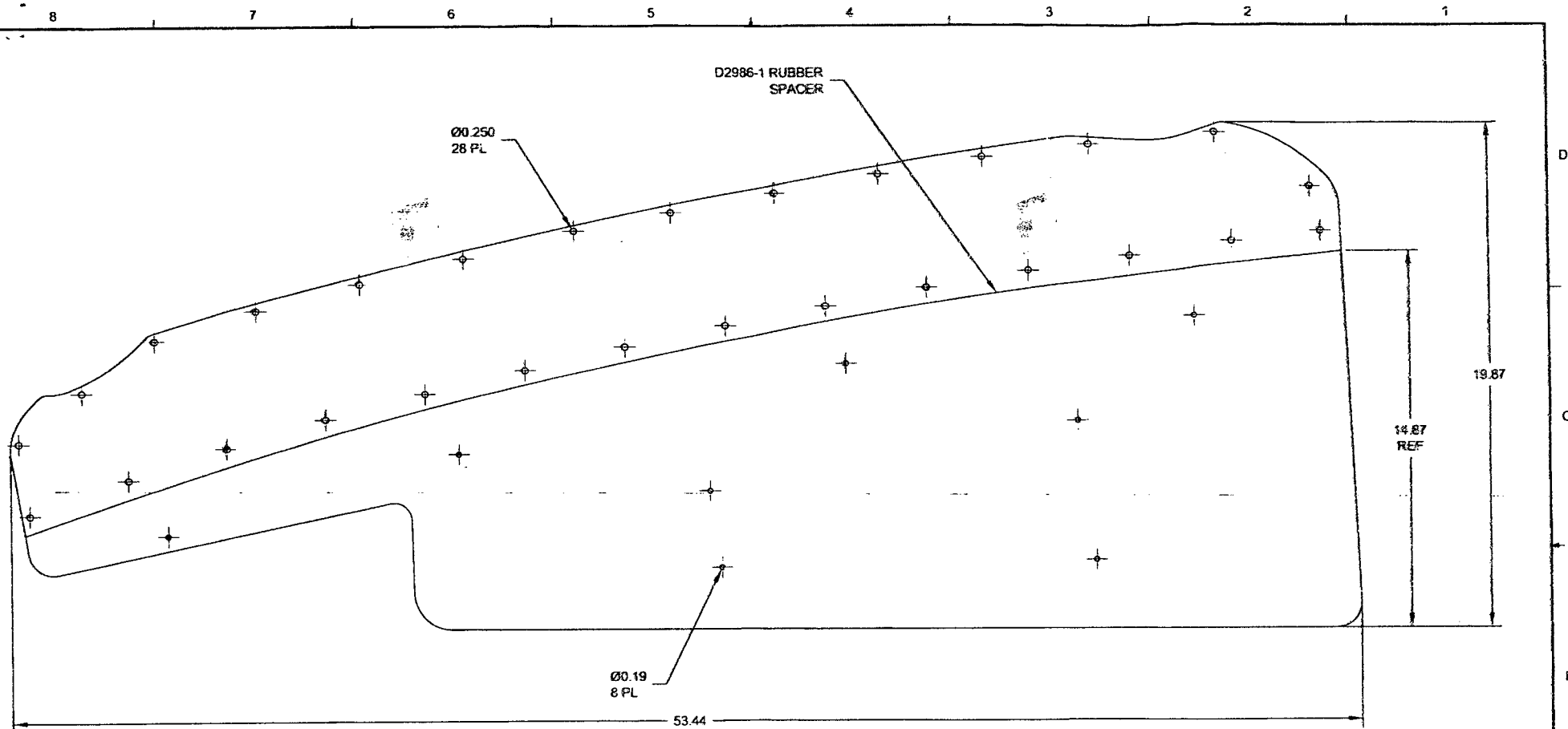
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3187-2 SPACEPOD FLOOR

D3187-2 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09.01.05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3187	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.01.05	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS TO BE KEPT UNDER LOCK AND KEY AND NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

W/0 54940

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries